

D3937-3 SHEET METAL BACKING STRIP

50772

RELEASED
2009-08-28
NR

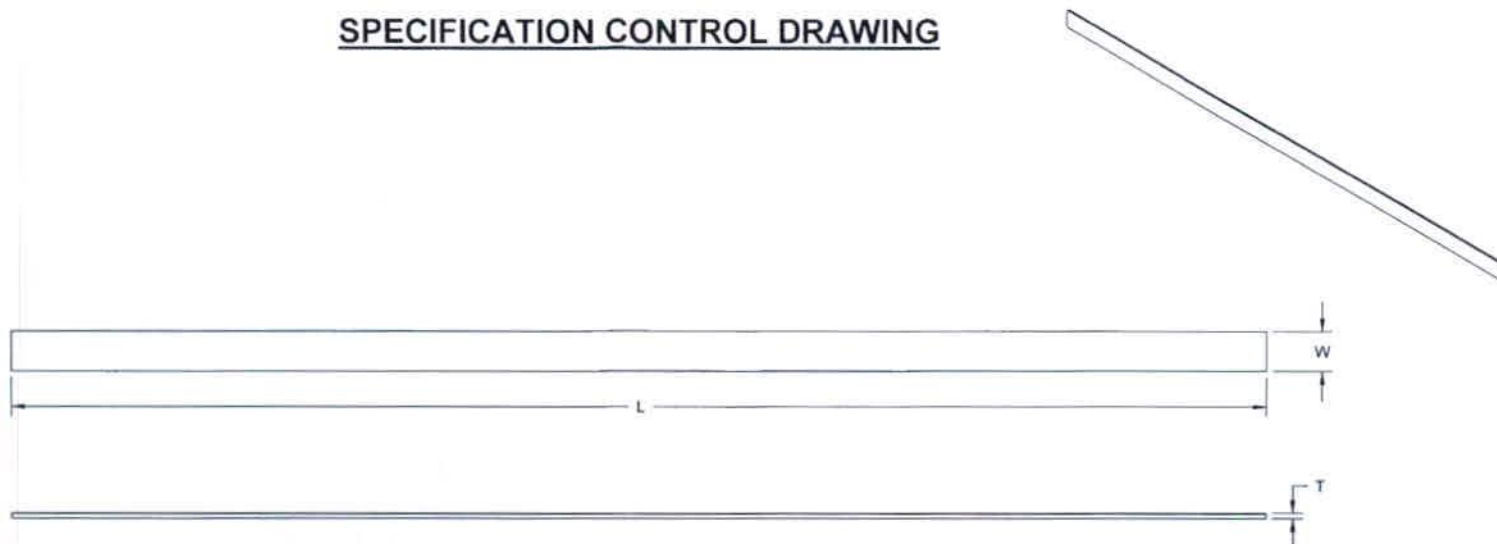
NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.032 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

| | | | |
|------------|----------|---|--------------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | AS | DRAWING NO. | REV. A |
| MFG. APPR. | | D3937 | SHEET 3 OF 3 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | LUMINESCENT STRIP | NTS |
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1875

SPECIFICATION CONTROL DRAWING



D3937-1 LUMINESCENT STRIP

| DART PART NUMBER | LENGTH "L" | WIDTH "W" | THICKNESS "T" | SUPPLIER | SUPPLIER PART NUMBER | WEIGHT |
|------------------|------------|-----------|---------------|-------------------|----------------------|----------|
| D3937-1 | 21.0 | 0.67 | 0.09 | LUFTHANSA TECHNIK | PL88-990LH00 | 0.04 LBS |

50772

RELEASED
2009-08-28
WP

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE TABLE

| | | | |
|------------|--------------------|--|--------------|
| DESIGN | <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | <i>[Signature]</i> | | |
| CHECKED | <i>AS</i> | DRAWING NO. D3937 | REV. A |
| MFG. APPR. | <i>[Signature]</i> | SHEET 2 OF 3 | |
| APPROVED | <i>[Signature]</i> | TITLE LUMINESCENT STRIP | SCALE NTS |
| DE APPR. | <i>[Signature]</i> | <small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |
| DATE | 09.06.02 | | |

| ITEM NO. | QTY. -041 | PART NUMBER | DESCRIPTION |
|----------|--------------|-------------|----------------------------|
| 1 | X | D3937-041 | LUMINESCENT STRIP ASSEMBLY |
| 2 | 1 | D3937-1 | LUMINESCENT STRIP |
| 3 | 1 | D3937-3 | SHEET METAL BACKING STRIP |

PEEL SELF-ADHESIVE BACKING FROM
D3937-1 LUMINESCENT STRIP.
ALIGN PART EDGES AND STICK TO
D3937-3 SHEET METAL BACKING STRIP

D3937-041 LUMINESCENT STRIP ASSEMBLY

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3937-041" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.06 lbs

| | | |
|------------|--------------------|--|
| A | NEW ISSUE | 09.06.02 |
| REV. | DESCRIPTION | BY DATE |
| DESIGN | <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA |
| DRAWN | <i>[Signature]</i> | |
| CHECKED | <i>AJS</i> | DRAWING NO. REV. A |
| MFG. APPR. | <i>[Signature]</i> | D3937 SHEET 1 OF 3 |
| APPROVED | <i>[Signature]</i> | TITLE SCALE |
| DE APPR. | <i>[Signature]</i> | LUMINESCENT STRIP NTS |
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50772
RELEASED
2009-08-28
MT

Picklist Print

July 22, 2009 9:11:04 AM

Page 1

Work Order ID: 50772



Parent Item: D3937-041RevA-Preliminary



Parent Item Name: Photoluminescent Strips



Start Date: 7/23/09

Required Date: 7/23/09

Comments:

Start Qty: 96.00

Required Qty: 96.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D3937-1RevA-PRELIM  | | Manufactured | No | | | | Each | 0.0000 | 1.0000 | | | |
| Luminescent Strip D3937-3A-Prelim  | | Manufactured | No | | | | Each | 0.0000 | 1.0000 | | | |
| Backing Strip | | | | | | | | | | | | |

Handwritten notes:
A large blue 'X' is drawn over the table rows.
An arrow points from the 'X' to the handwritten number '50557' next to the first row.
Another arrow points from the 'X' to the handwritten number 'B50073' next to the second row.

Work Order ID 50772

July 22, 2009 8:47:17 AM



Page 4

Item ID: D3937-041
Revision ID: A-Preliminary
Item Name: Photoluminescent Strips

Accept



Setup Start



Stop



Start Date: 7/23/09 Start Qty: 96.00



Cust Item ID:

Required Date: 7/23/09 Req'd Qty: 96.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

~~09/07/09~~
09/09/01
U 97.0724

ENGINEERING
APPROVAL

Work Order ID 50772

July 22, 2009 8:47:17 AM



Page 3

Item ID: D3937-041

Accept



Setup Start



Revision ID: A-Preliminary

Stop



Item Name: Photoluminescent Strips

Start Date: 7/23/09 Start Qty: 96.00



Cust Item ID:

Required Date: 7/23/09 Req'd Qty: 96.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

0.00



Small Fab

Memo

0.00

Small Fab

1- Align part edges and stick strip to D3937-3 as per dwg

(240 x) m.d 09/07/23

160

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

ENGINEERING
APPROVAL
26/09/09

240
QSP015

26/09/23

170

0.00



Packaging

Identify as per dwg & Stock Location: _____

Memo

0.00

Packaging

1/4/24

(240)

Work Order ID 50772

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Page 2

Item ID: D3937-041

Accept



Setup Start



Revision ID: A-Preliminary

Stop



Item Name: Photoluminescent Strips

Start Date: 7/23/09

Start Qty: 96.00



Cust Item ID:

Required Date: 7/23/09

Req'd Qty: 96.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

130



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

Handwritten signature/initials

PRELIMINARY ISSUE

Work Order ID 50772 -1

July 22, 2009 8:47:17 AM

PRELIMINARY ISSUE



SPUT

32 sent to Eagle
for 2554

Page 1

Item ID: D3937-041

Accept



Setup Start



Revision ID: A-Preliminary

Stop



Item Name: Photoluminescent Strips

Start Date: 7/23/09

Start Qty: 96.00



Cust Item ID:

Required Date: 7/23/09

Req'd Qty: 96.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

0.00

1-Cut as per Dwg D3937 (Make D3937-3)

Dwg Rev:

Prog Rev:

2-Deburr if necessary

Done on D3937-3 U

110

0.00



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

B50557